

Date: Friday, 6/1/2007 1:02:51 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: GASKET		
Job Number	: 32746					
Estimate Number	: 12722					
P.O. Number	: N/A		Part Number	: D353615		
This Issue	: 6/1/2007	S.O. No. : N/A	Drawing Number	: D3536 REV A		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: A		
Previous Run	: 31994		Material	: N/A		
Written By			Due Date	: 6/8/2007		
Checked & Approved By			Qty:	20	Um:	Each
Comment	: Est Rev A		New Issue 07-02-14 JLM			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MNE060S063	NEOPRENE SHEET 0.063
Comment: Qty.: 1.0340 sf(s)/Unit Total : 20.6808 sf(s) NEOPRENE SHEET 0.063 Batch: ml03104 ml 07 06 03		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A ml 07 06 03		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/06/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Friday, 6/1/2007 1:02:51 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 32746

Part Number: D353615

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(26)

Comment: FINAL INSPECTION/W/O RELEASE

6/07/06/05

Job Completion



C20706/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32746
Description: Gasket		Part Number:	D3536-15
Inspection Dwg:	D3536	Rev:	A

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

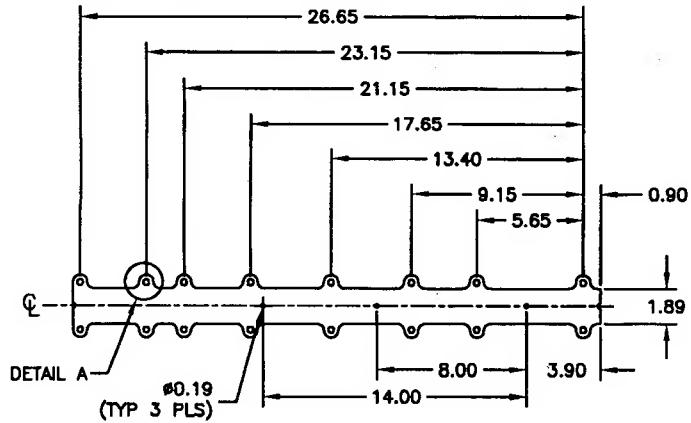
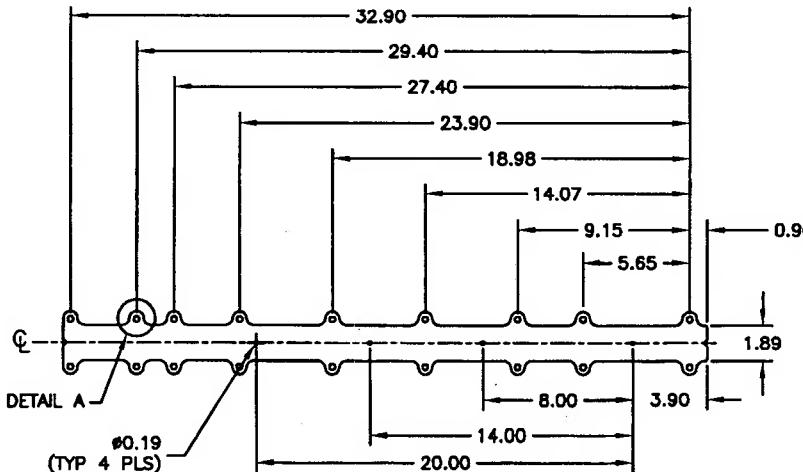
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.15	+/-0.030	39.15	✓		M.T	
35.65	+/-0.030	35.65	✓		M.T	
33.65	+/-0.030	33.65	✓		M.T	
30.15	+/-0.030	30.15	✓		M.T	
24.90	+/-0.030	24.90	✓		M.T	
19.65	+/-0.030	19.65	✓		M.T	
14.40	+/-0.030	14.40	✓		M.T	
9.15	+/-0.030	9.15	✓		M.T	
5.65	+/-0.030	5.64	✓		<del>M.T</del> VERN	
3.90	+/-0.030	3.89	✓		VERN	
8.00	+/-0.030	8.00	✓		M.T	
16.00	+/-0.030	16.00	✓		M.T	
24.00	+/-0.030	24.00	✓		M.T	
0.30	+/-0.030	0.300	✓		VERN	
0.30	+/-0.030	0.300	✓		VERN	
1.89	+/-0.030	1.88	✓		VERN	
00.19	+0.005/-0.001	0.19	✓		VERN	

Measured by: *ML* *ML*  
Date: 07.06.04

Audited by: *SA*  
Date: 07.06.04

Prototype Approval: N/A  
Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM <i>KA</i>	<i>SA</i>

**DART**~~04.02.12~~**D3536-11 GASKET****D3536-13 GASKET**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *32746*

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

**Copyright © 2006 by DART AEROSPACE USA, INC.**

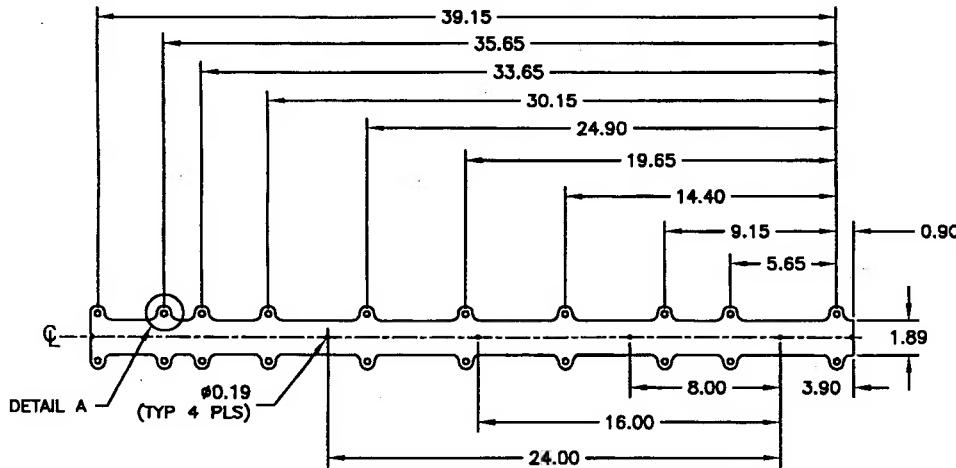
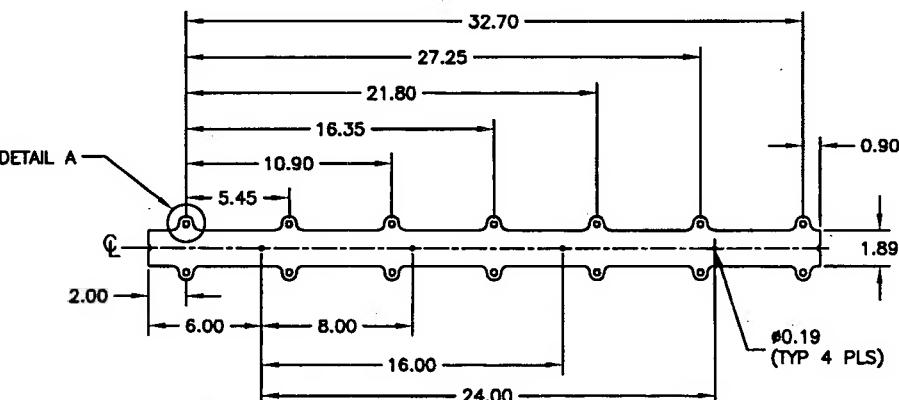
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CB	CB	
CHECKED	APPROVED	DRAWING NO.
<i>MH</i>	<i>SH</i>	D3536
DATE		SCALE
06.10.25		1:10
A	06.10.25	NEW ISSUE

**DART**

RECEIVED  
07.02.12  
DART

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A

DRAWING NO. D3536  
SHEET 2 OF 6  
SCALE 1:10

**D3536-15 GASKET****D3536-21 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK IN PROGRESS

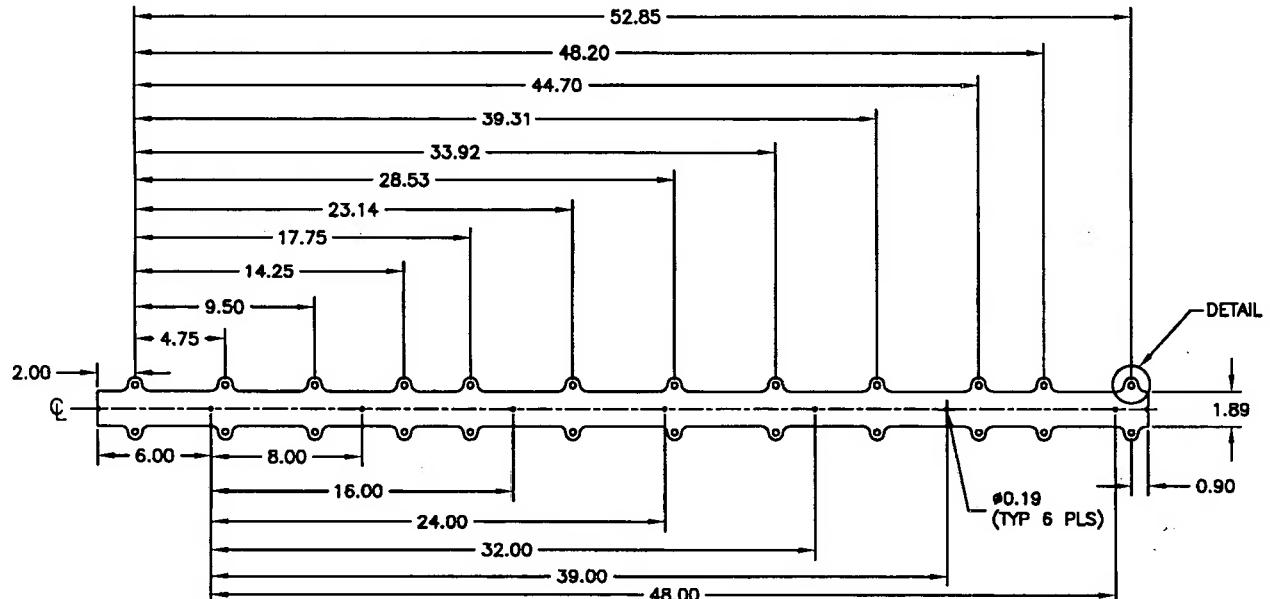
SHOP COPY  
RETURN TO  
ENGINEERING

**DART**

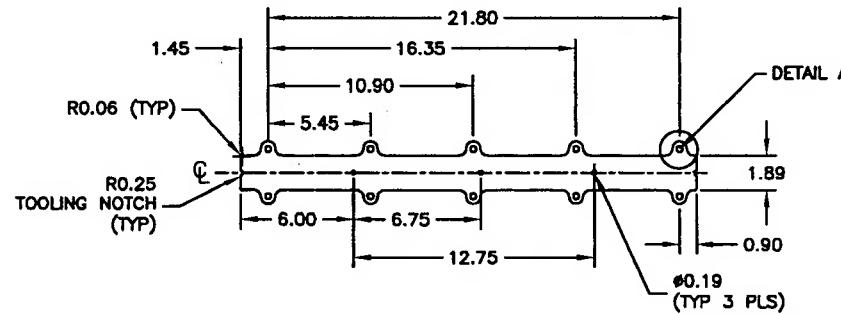
07.02.12  
FBIK/AS/ED

DESIGN	C.B	DRAWN BY	C.B	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	CH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A

SCALE  
1:10  
SHEET 3 OF 6



**D3536-23 GASKET**



**D3536-25 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

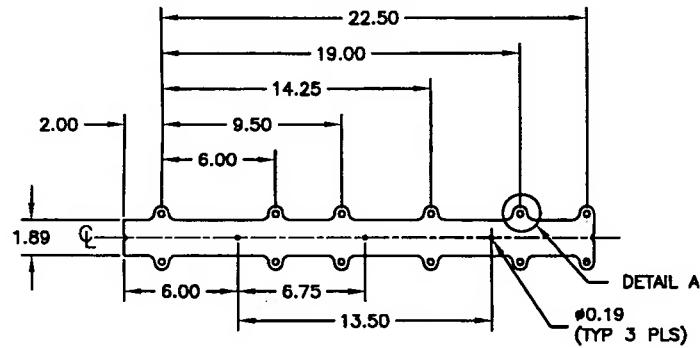
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

**Copyright © 2006 by DART AEROSPACE USA, INC.**

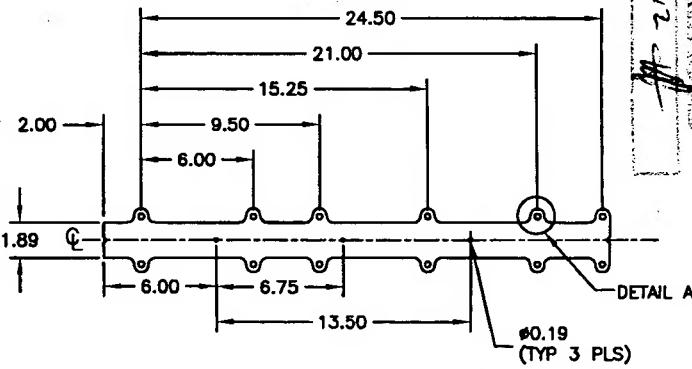
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 2146

**DART**

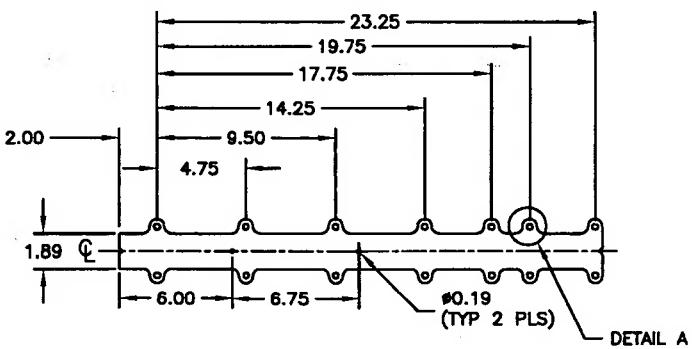
07.02.12 *[Signature]*



**D3536-31 GASKET**



**D3536-33 GASKET**



**D3536-35 GASKET**

DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3536
DATE 06.10.25	FILE GASKET	SCALE 1:10

**NOTES**

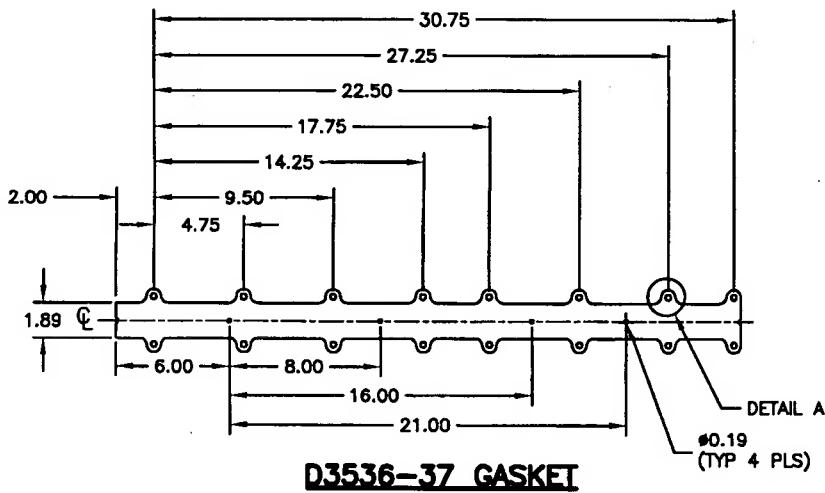
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

WORK ORDER  
NO. 22746  
SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

**DART**

DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <b>PH</b>	APPROVED <b>PH</b>	DRAWING NO. D3536
DATE 06.10.25	TITLE GASKET	SCALE 1:10

07.02.02  
*[Signature]*

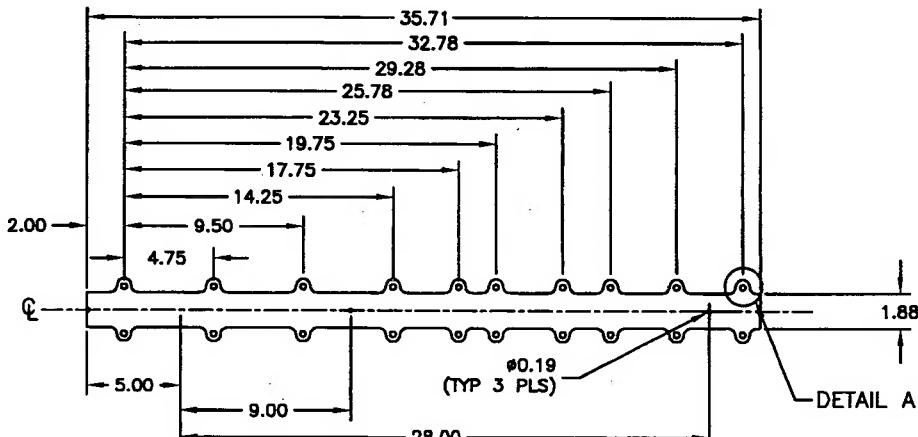


**D3536-37 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

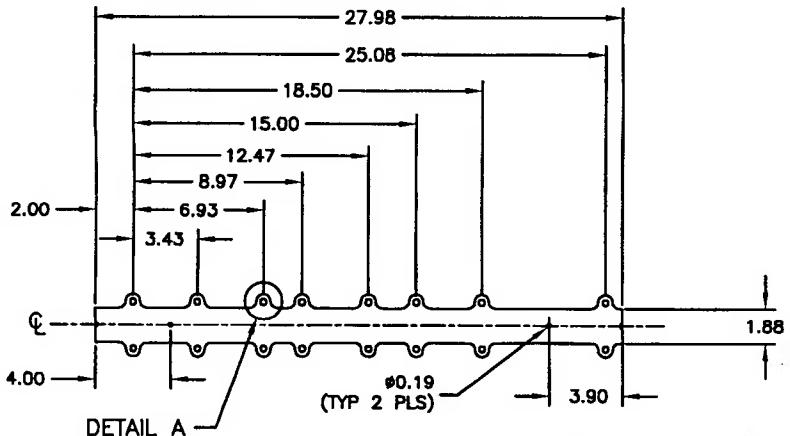
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. 32746



**D3536-39 GASKET**

**DART**

07.02.12

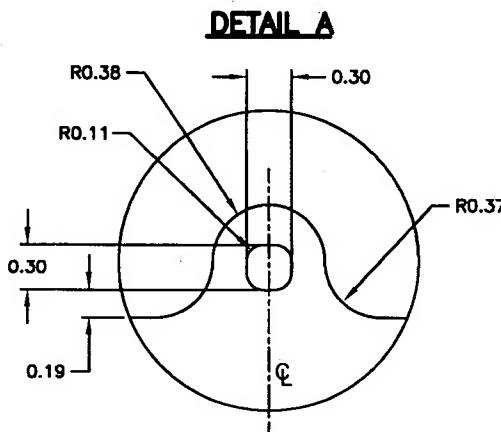


**D3536-41 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 246



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. A
CB	CB	D3536	
CHECKED	APPROVED	DRAWING NO.	SHEET 6 OF 6
PH	PH	TITLE	SCALE
06.10.25		GASKET	1:10